

Work Order ID 150001

Thursday, August 18, 2016 9:25:24 AM

150001

Page 1

Item ID: D212-580-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Dual Cargo Mirror Installation
 Start Date: 8/18/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/22/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **AUG 18 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2161	B2							DAS 21 9-89	1608-18
IIN-D212-580-1	B								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels as per PPP D212-580-041 CHG004								
160	Pick Kit	0.00							
160									
Packaging	Memo	0.00							
Packaging									

DAS 27 9-89
AUG 22 2016
DAS 21 9-89
AUG 18 2016
DAS 28 9-89
AUG 18 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Item ID: D212-580-041**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Item Name:** Dual Cargo Mirror Installation**Stop*****NS2*****Start Date:** 8/18/2016 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 8/22/2016 **Req'd Qty:** 2.00***2*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

170

QC4- 100% Inspect kits for completeness

0.01

170

QC

Memo

0.01

Quality Control

XO

DAS
27
9-89

AUG 22 2016

180

Packaging

0.00

180

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D212--580-041
LOCATION: FG010

2X

DAS
27
9-89

AUG 22 2016

190

QC21- Final Inspection - Work Order Release

0.02

190

QC

Memo

0.03

Quality Control

DAS
21
9-89

AUG 22 2016

DAS
21
9-89

AUG 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____			
Misidentified ☐	☐	Past Due ☐	☐				

Thursday, August 18, 2016 9:25:30 AM

150001

D212-580-041

Required Date: 8/22/2016

Required Qty: 2.00

IPP rev:J

AUG 18 2016

Picklist Print

Thursday, August 18, 2016 9:25:30 AM

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Work Order ID: 150001

150001

Parent Item: D212-580-041

D212-580-041

Parent Item Name: Dual Cargo Mirror Installation

Start Date: 8/18/2016

Required Date: 8/22/2016

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-08

Purchased

No

100

Each

374.0000

4

8

MS27039-1-08

Screw

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

69

m128636

69

GA

72

125654

1

m128636

71

ST281

233

m134762

233

5

AUG 18 2016

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 150001

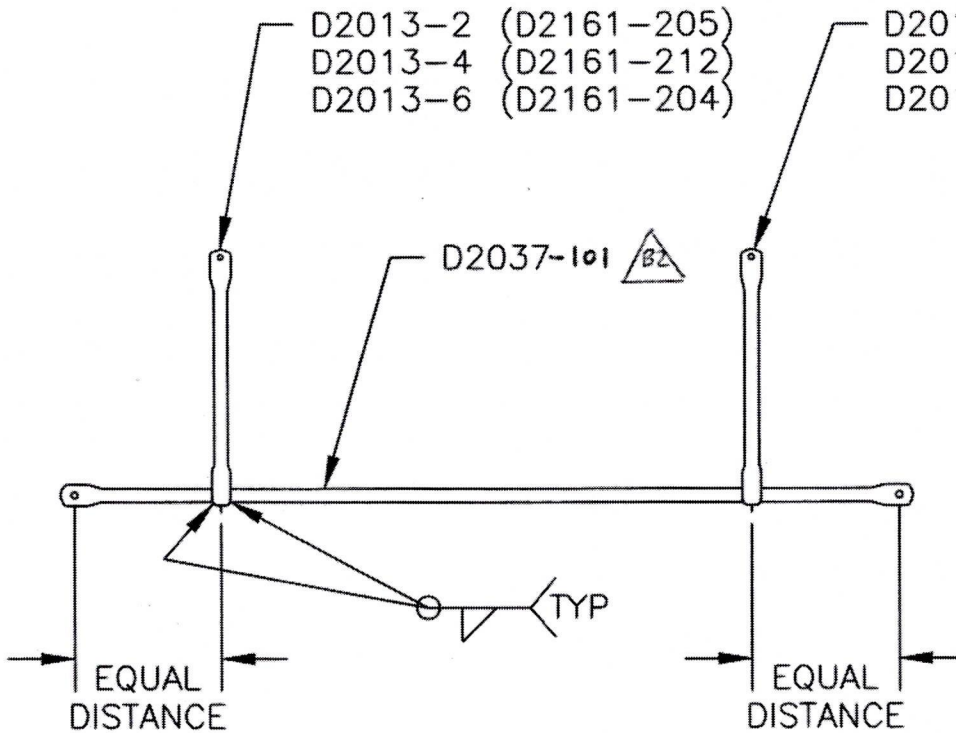
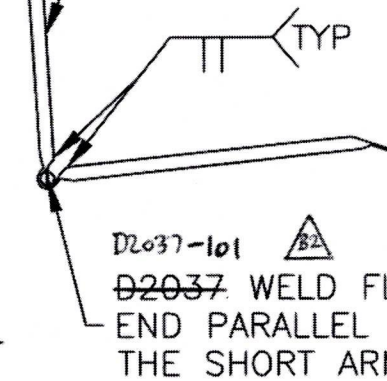
MCS

160818

DART



PLACE SHORTER ARM
ON SIDE OF JIG DT8065
LABELED FWD (TYP)



DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212

NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 $\triangle B1$

DESIGN	JOB	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	JB	APPROVED	REV. B
DATE	99.06.07	TITLE	SHEET 1 OF 1
		MIRROR BRACKET	SCALE
		NEW ISSUE	NTS
		REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	
		CHANGE FINISH	
		D2037-101 W/	

RELEASED
KE 99.06.10

4.0 PARTS LIST

Qty 562 -041	Qty 563 -041	Qty 580 -041	Part Number	Description
X			D204-562-041	DUAL MIRROR INSTALLATION
	X		D205-563-041	DUAL MIRROR INSTALLATION
		X	D212-580-041	DUAL MIRROR INSTALLATION
2	2	2	D3439-101	MIRROR (WAS D2011-103)
1			D2161-204	MIRROR BRACKET
	1		D2161-205	MIRROR BRACKET
		1	D2161-212	MIRROR BRACKET
*2	*2	*2	D3015-3	LOCKNUT
*2	*2	*2	AN960JD516	WASHER
		8	MS20426AD3-4	RIVET, COUNTERSUNK
		4	D4164-041	NUT PLATE ASSEMBLY
4	4	4	MS27039-1-08	SCREW

* PARTS ARE INCLUDED WITH D3439-101 MIRROR

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Revision: B

Date: 12.06.13